

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000653**Date Inspected:** 18-Oct-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Plate Material		

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Timothy McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following Plate Material Storage Yard:

QA Inspector Timothy McClendon received plate material list for batch #25, production list No. 1977 ~ 2057 from American Bridge/Fluor (ABF). QA Inspector Timothy McClendon went to the ZPMC material storage yard accompanied by ZPMC QA Mr. Ken Zhang Jiadi, and ZPMC QC Miss Cary Wu Min. QA Inspector Timothy McClendon observed a total of 71 out of 81 plates for batch #25. The plates were observed for their general condition and markings. Plate material thicknesses were 6mm ~ 22mm. The plates were designated as A709M-345T2-X and A709M-345T2-X-S. QA Inspector Timothy McClendon compared information on plate list against markings on plate and no discrepancies were discovered. Plate material list for batch #25 was accompanied with Material Test Reports (MTR). The MTR's could not be reviewed on this date and will be reviewed at the earliest opportunity. QA Inspector Timothy McClendon assigned lot number B94-003-07 to the 71 Plates observed on this date.

QA Inspector Timothy McClendon observed plate No. 2019, ID#NG070882G107, Batch #072037620403, 8mm(thickness)x2800mm(width)x12000mm(length) and Material tracking report #3593, having deformation on outer edge starting approximately 280cm from the end of the plate continuing approximately to 350cm. Photographs were taken and dimensions of the deformed areas were recorded and are attached. ZPMC QC Miss Cary Wu Min was aware of the deformed area; however ZPMC QC Miss Cary Wu Min was unaware of how the

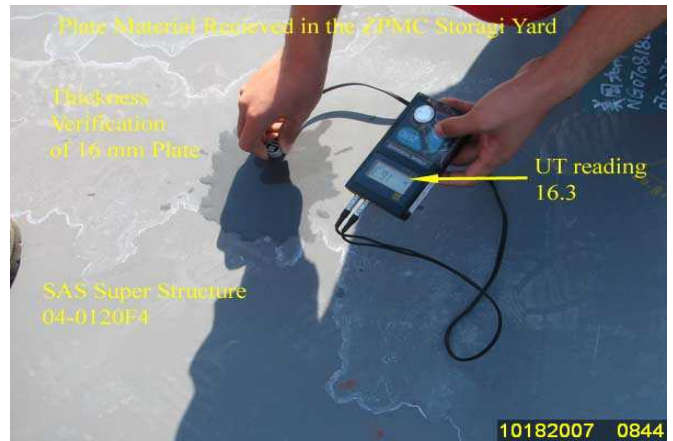
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## WELDING INSPECTION REPORT

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deformation had occurred. QA Inspector Timothy McClendon did not accept the above mentioned plate. QA Inspector Timothy McClendon informed Task Leader Robert Cuellar of the above.



### Summary of Conversations:

As stated within the report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** McClendon, Timothy

Quality Assurance Inspector

**Reviewed By:** Cuellar, Robert

QA Reviewer

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